

Date: Tuesday, 04/11/2008 10:29:37 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
Job Number : 43184 -3
Estimate Number : 12967
P.O. Number :
This Issue : 04/11/2008 S.O. No. :
Prsht Rev. : NC Part Number : D36373
First Issue : / / Type : SMALL /MED FAB Drawing Number : D3637 REV B
Previous Run : 42823 Material : B
Due Date : 11/11/2008 Qty: 24 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC
Est Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.1407 sf(s)/Unit Total : 3.3768 sf(s)
2024-T3 .050 sheet
Batch: 107711 IB 8-11-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3637
Dwg Rev: B
Prog Rev: B

IB 8-11-4

(40)

2-Deburr if necessary

IB 8-11-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-11-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

806/4/04 (440)

counter

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Form as per Dwg D3637

806/11/05

(4)

(36)

32

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 43184

Part Number: D36373

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- drill holes as per dwg using DT8979

2- c'sink holes as per dwg

3-deburr

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: Fl61

12.0

QC21

FINAL INSPECTION/W/O RELEASE

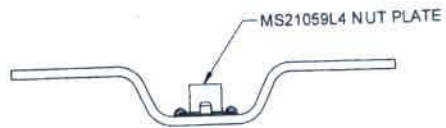


Comment: FINAL INSPECTION/W/O RELEASE

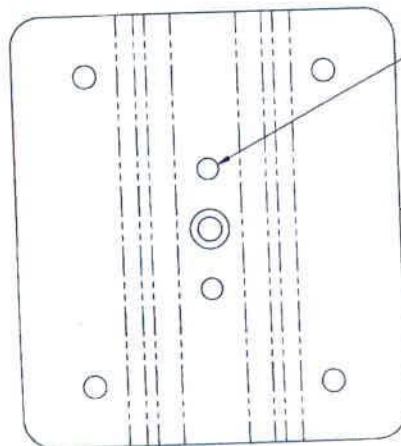
Job Completion





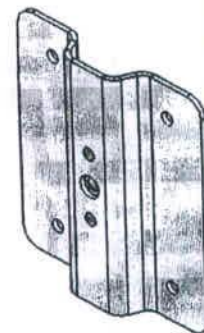


MS21059L4 NUT PLATE



MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

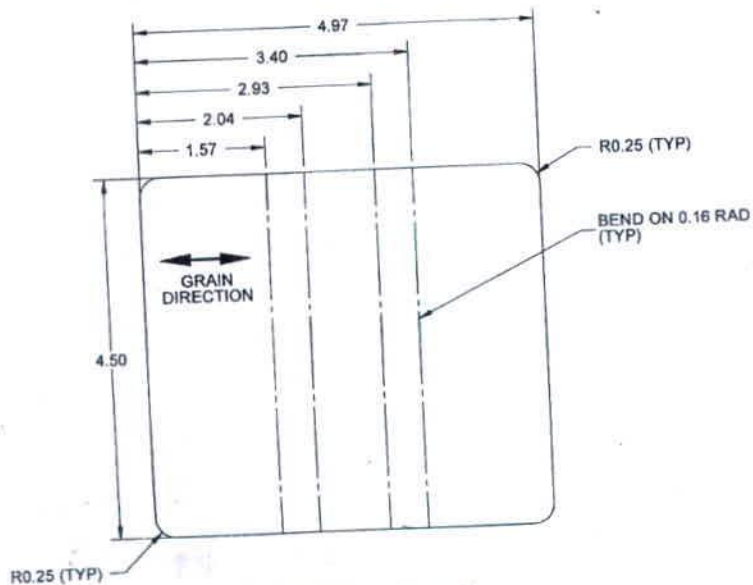
QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

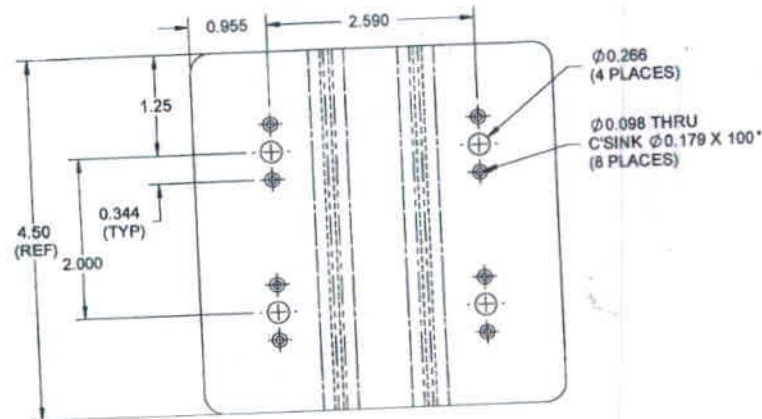
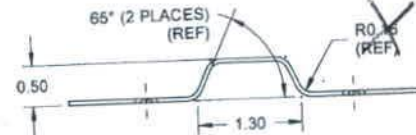
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

Handwritten: w/o 4384

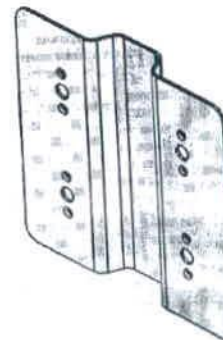
DESIGN	IS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3637	SHEET 1 OF 3
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	BRACKET	1:1
DATE	07.12.18	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD</small>	



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



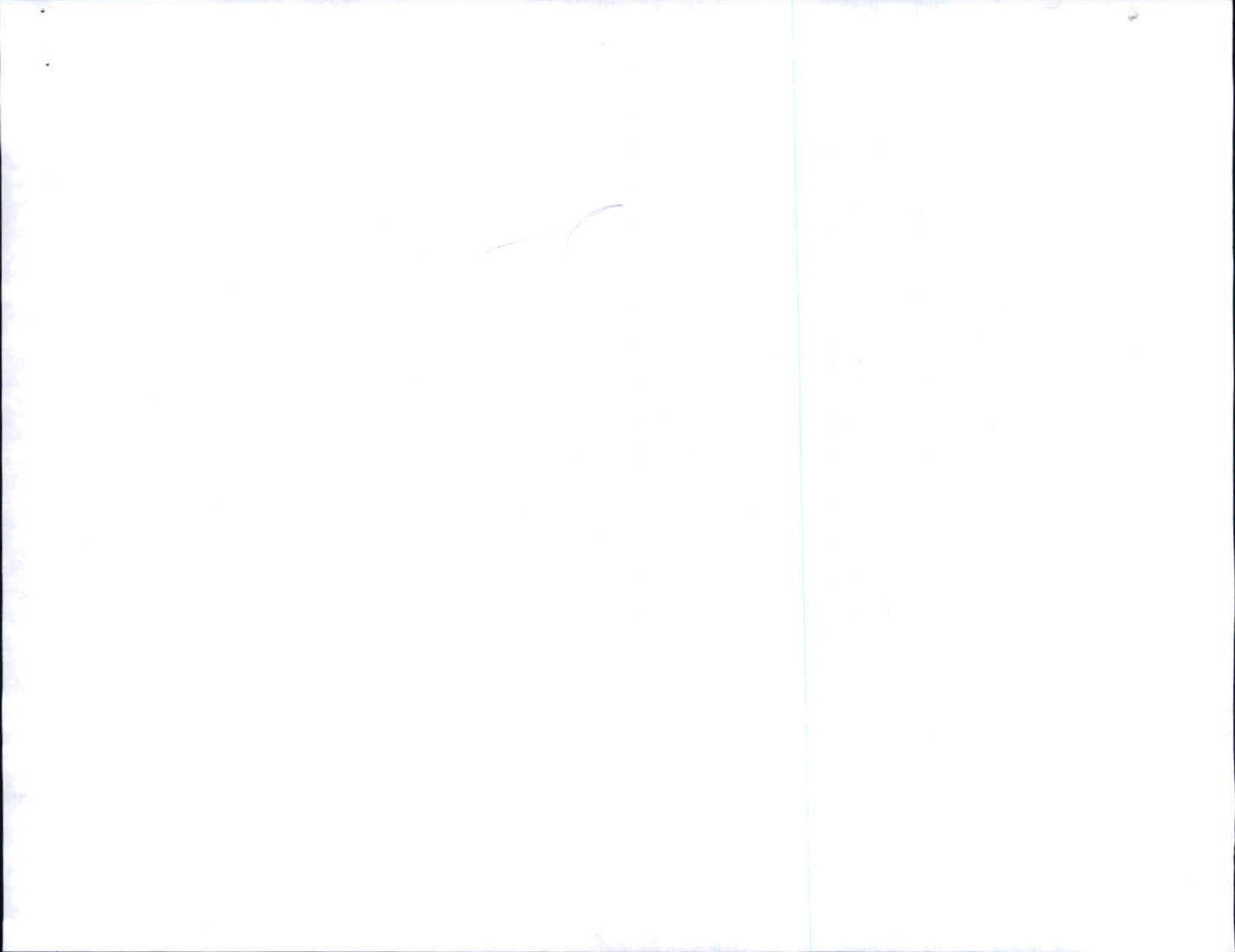
- D3637-3 NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	ED	D3637	SHEET 3 OF 3
APPROVED	NV	TITLE	SCALE
DE APPR.		BRACKET	23
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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1.410
2.590
4.500

1.410
2.590
4.500





WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: D3637-3 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: A Date: 08.11.13
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR: <u>43184-3</u>								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date		
<u>08.11.04</u>	<u>5</u>	<u>RO.16 was cracking</u>	<u>RA</u> <u>08.11.04</u>	<u>change to RO.18</u> <u>- NO MORE CRACKING</u> <u>PRESENT</u>		<u>RA</u> <u>08.10.04</u>	<u>S</u> <u>08.11.04</u>	<u>S</u> <u>08.11.04</u>

NOTE: Date & initial all entries

